



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200
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RBE703A94-1130-01-23

Job Sheet 184011



5133643

Part No: RBE703A94-1130-01-23

Job Qty: 3 ea

Part Name: Deflection Clip Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/1/18

Job Tracking No:

Due Date: 10/15/18

Created By: Logan David

Type: Stock

Description:

Note: DWG RBE703A94-1130-01 Rev K IPP Rev.A 17.08.09 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev B DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		10/15/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	3 pcs		10/15/18	0.00	3.00	Small Fab-3		
120	QC	3 pcs		10/15/18	0.00	0.00	QC5		
130	Packaging	3 pcs		10/15/18	0.00	0.00	Packaging3-1		
140	QC21-SA	3 Ea		10/15/18	0.00	0.00	QC21		

Part Op 110 - 1-Assemble as per DWG. Sheet 9. 2-Apply Loctite to mating surfaces of item -33 and -27 -Loctite 263
Descriptions: B _____ Exp.: _____ ***Item -33 should not protrude past the surface of item -27***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
64 90353A214	Pan Head Machine Screw M4 x 0.7mm x 12mm	6 Ea (2 ea)	90-Start up Operation	Fm138414-6
51 91595A155	Dowel Pin 4mm x 12mm	6 Ea (2 ea)	90-Start up Operation	5091269
40 98296A882	Slotted Spring Pin Ø1/8" X 7/8"	3 Ea (1 ea)	90-Start up Operation	Fm138414-34
41 98338A022	Cotter Pin Ø3/64" X 1/2"	6 Ea (2 ea)	90-Start up Operation	Fm138414-35
RBE703A94-1130-01-25	Tab Adjuster Handle	3 Ea (1 ea)	90-Start up Operation	5126672
RBE703A94-1130-01-27	Tab Adjuster Body	3 Ea (1 ea)	90-Start up Operation	5128330
RBE703A94-1130-01-29	Tab Adjuster Clamp	3 Ea (1 ea)	90-Start up Operation	5126936
RBE703A94-1130-01-31	Tab Adjuster Gauge Plate	3 Ea (1 ea)	90-Start up Operation	5127281
RBE703A94-1130-01-33	Adjuster	6 Ea (2 ea)	90-Start up Operation	5127539
31 6NF45/A	Knurled Nut	6 Ea (2 ea)	90-Start up Operation	5093862

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	6NF45/A	6	30	0
	90353A214	6	62	0
	91595A155	6	112	0
	98296A882	3	231	0
	98338A022	6	62	0
	RBE703A94-1130-01-25	3	0	0
	RBE703A94-1130-01-27	3	0	0
	RBE703A94-1130-01-29	3	0	0
	RBE703A94-1130-01-31	3	0	0
	RBE703A94-1130-01-33	6	5	0

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Part Specifications

Specifications could not be found.

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DQA: _____ Date: _____



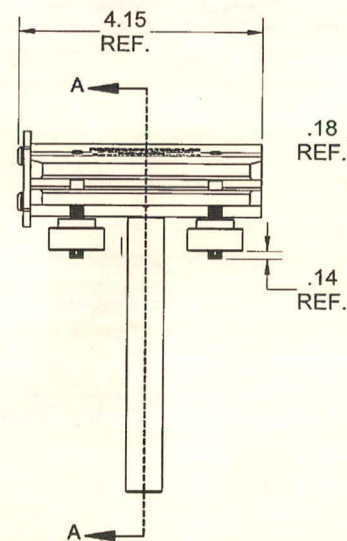
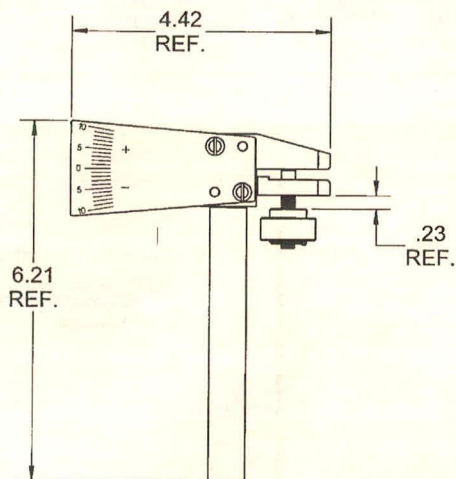
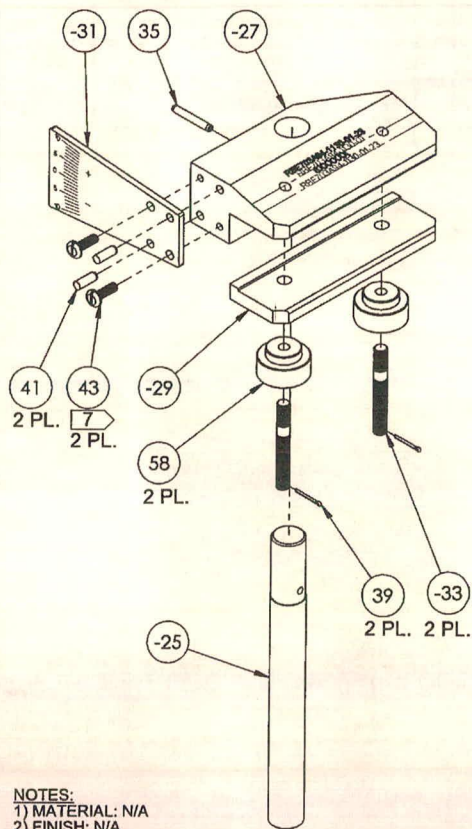
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

ITEM #	QTY	PART #	TITLE	PG
-25	1	RBE703A94-1130-01-25	TAB ADJUSTER HANDLE	10
-27	1	RBE703A94-1130-01-27	TAB ADJUSTER BODY	11
-29	1	RBE703A94-1130-01-29	TAB ADJUSTER CLAMP	12
-31	1	RBE703A94-1130-01-31	TAB ADJUSTER GAUGE PLATE	13
-33	2	RBE703A94-1130-01-33	ADJUSTER	14
35	1	McMaster#98296A882	SPRING PIN Ø1/8 X 7/8	-
39	2	McMaster#98338A022	COTTER PIN Ø3/64 X 1/2	-
41	2	McMaster#91595A155	DOWEL PIN 4mm X 12mm	-
43	2	McMaster#90353A214	PAN HEAD M4 x 0.7 x 12mm	-
58	2	J.W. WINCO #6NF46A	KNURLED NUT M6 X 1.0 DIN 6303 TYPE A	-



SECTION A-A

RBE703A94-1130-01-23 DEFLECTION CLIP ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) HEAT TREAT: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) APPLY LOCTITE 263 OR EQUI.

		Hawthornbury, Ontario, Canada	
		TITLE DEFLECTION CLIP ASSY	
DWG NO. RBE703A94-1130-01-23		REV K	
DESIGN BY: VM 8/28/2017	XXX ± .005 FRACTIONS & 1/8	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED 2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: VM 11/24/2017	XX ± .01 ANGLES 2.5°		
CHECKED: VM 11/30/2017	X ± .1 SURFACES ± 12°		
MFG. APPR: IDP 11/30/2017			
APPROVED: VM 11/30/2017	DATE: 11/24/2017	AFTER PLATING	
SCALE: NTS	WEIGHT: N/A	SHEET 9 OF 17	
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WORK ORDER NON-CONFORMANCE / UPDATE

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